



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4294-1

Job Sheet 185052



Part No: D4294-1

Job Qty: 6 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-25 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	10/31/18	10/31/18	0.00	0.00	Start Up Machining-2		SBL 18/10/28
100	Bandsaw	6 pcs	10/31/18	10/31/18	0.00	0.43	Bandsaw1		SBL 18/10/28
110	CNC Vertical Machining	6 pcs	10/31/18	10/31/18	0.46	5.00	HAAS 5 Axis		SBL / FRED 29-10-18
120	QC	6 pcs	10/31/18	10/31/18	0.00	0.00	QC2 Machining-2		SBL / FRED 29-10-18
130	QC	6 pcs	10/31/18	10/31/18	0.00	0.00	QC8 Machining-2		K+ 2018-11-03
140	HandFinish	6 pcs	10/31/18	10/31/18	0.00	0.37	HandFinish1		DR 18/11/05
145	Powdercoat	6 pcs	10/31/18	10/31/18	0.00	0.42	Powdercoat1		BL 18-11-5.
150	QC	6 pcs	10/31/18	10/31/18	0.00	0.00	QC3		
151	Small Fab	6 pcs	10/31/18	10/31/18	0.00	0.28	Small Fab-6		DAS
152	QC	6 pcs	10/31/18	10/31/18	0.00	0.00	QC5		38
180	Packaging	6 pcs	10/31/18	10/31/18	0.00	0.00	Packaging3-2		NOV 09 2018
190	QC21-SA	6 Ea	10/31/18	10/31/18	0.00	0.00	QC21		NOV 12 2018

Part Op 100 - Cut Blank to 7.125" ****GRAIN ALONG 4"*****

Descriptions: 110 - 1-Machine per folio FB008

145 - MASK THREADED HOLE

151 - INSTALL HELICOIL AS PER DWG

M138951

START: 2:30

OUT: 3:00 FINISH 1 3:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B4.000x4.000	7075-T73 Bar 4.0 X 4.0 Grain Direction Along 4" Wide	3.6000 ft (.6 ea)	90-Start up Operation	5043346+6
MS21209F1-10	Heli Coil	6 Ea (1 ea)	151-Small Fab	51205/6

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B4.000x4.000	4	24	0
151-Small Fab	MS21209F1-10	6	20	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.065Inches ± 0.010	0.075 0.055		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																															
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																												
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																												
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Date: _____		Step #: _____		QTY Effective: _____		MRB (QSI042) Approval																																													
Description Work Order Deviation																																																			
Dart Aerospace Ltd. 1270 Aberdeen Street Hewkebury, ON K64 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S122048 Part: D4294 - 1 Job No: 185052 Serial No/Batch: S122048 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/26/18				Completed By																																															
				Lead hand / Supervisor Approval Verification																																															
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temp total de Del + Vincent = 18 1/4 heure

Dans plex j'ai rempli étape 90-100.

Tu additionneras ton temps avec le mien

sur Haas 5 et co-signes avec moi jusqu'à

QC2-2.

Si tu as des questions tu m'en diras me

voit Del.

2	Fitting	0.063Inches ± 0.010	0.073 0.053	Radius
3	Fitting	0.305Inches + 0.030 - 0.010	0.335 0.295	
4	Fitting	3.170Inches ± 0.030	3.200 3.140	
5	Fitting	3.110Inches ± 0.030	3.140 3.080	
6	Fitting	0.325Inches ± 0.010	0.335 0.315	
7	Fitting	0.780Inches ± 0.010	0.790 0.770	
8	Fitting	0.800Inches ± 0.030	0.830 0.770	
9	Fitting	1.560Inches ± 0.010	1.570 1.550	
10	Fitting	0.500Inches ± 0.010	0.510 0.490	
11	Fitting	0.070Inches ± 0.010	0.080 0.060	
12	Fitting	0.390Inches ± 0.030	0.420 0.360	
13	Fitting	0.500Inches ± 0.010	0.510 0.490	
14	Fitting	0.880Inches ± 0.030	0.910 0.850	
15	Fitting	3.440Inches ± 0.030	3.470 3.410	
16	Fitting	2.450Inches ± 0.010	2.460 2.440	
17	Fitting	2.040Inches ± 0.030	2.070 2.010	
18	Fitting	1.528Inches ± 0.010	1.538 1.518	
19	Fitting	0.300Inches ± 0.010	0.310 0.290	
20	Fitting	0.738Inches ± 0.010	0.748 0.728	
21	Fitting	0.250Inches ± 0.030	0.280 0.220	
22	Fitting	3.375Inches ± 0.010	3.385 3.365	
23	Fitting	4.8750Inches ± 0.0100	4.8850 4.8650	
24	Fitting	1.670Inches ± 0.010	1.680 1.660	
25	Fitting	0.386Inches + 0.006 - 0.001	0.392 0.385	
26	Fitting	0.266Inches + 0.006 - 0.001	0.272 0.265	
27	Fitting	6.810Inches ± 0.030	6.840 6.780	
28	Fitting	6.350Inches ± 0.030	6.380 6.320	
29	Fitting	1.460Inches ± 0.030	1.490 1.430	
30	Fitting	0.050Inches ± 0.010	0.060 0.040	
31	Fitting	3.440Inches ± 0.010	3.450 3.430	
32	Fitting	4.968Inches ± 0.010	4.978 4.958	
33	Fitting	0.875Inches + 0.010 - 0.001	0.885 0.874	
34	Fitting	0.332Inches + 0.020 - 0.010	0.352 0.322	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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35	Fitting	0.750Inches $\pm$ 0.010	0.760 0.740
36	Fitting	6.490Inches $\pm$ 0.030	6.520 6.460
37	Fitting	0.691Inches $\pm$ 0.010	0.701 0.681
38	Fitting	0.640Inches $\pm$ 0.030	0.670 0.610
39	Fitting	0.201Inches + 0.005 - 0.001	0.206 0.200
40	Fitting	0.320Inches $\pm$ 0.010	0.330 0.310
41	Fitting	100Degrees $\pm$ 0	100 100
42	Fitting	0.764Inches $\pm$ 0.010	0.774 0.754
43	Fitting	0.381Inches + 0.000 - 0.001	0.381 0.380
44	Fitting	1.405Inches $\pm$ 0.010	1.415 1.395
45	Fitting	1.125Inches $\pm$ 0.010	1.135 1.115

Plex 10/22/18 11:20 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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DART AEROSPACE LTD		Work Order:	
Description: Fitting		Part Number:	D4294-1
Inspection Dwg: D4294 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.065	+/-0.010	0.062	✓			
R0.063	+/-0.010	0.0625	✓		RC	
0.305	+0.030/-0.010	0.304	✓			
3.17	+/-0.030	3.156	✓			
3.11	+/-0.030	3.094	✓			
0.325	+/-0.010	0.328	✓			
0.780	+/-0.010	0.780	✓			
0.80	+/-0.030	0.798	✓			
1.560	+/-0.010	1.562	✓			
0.500	+/-0.010	0.498	✓			
0.070	+/-0.010	0.070	✓			
0.39	+/-0.030	0.380	✓			
0.500	+/-0.010	0.506	✓			
0.88	+/-0.030	0.879	✓			
3.44	+/-0.030	3.438	✓			
2.450	+/-0.010	2.450	✓			
2.04	+/-0.030	2.047	✓			
1.528	+/-0.010	1.528	✓			
0.300	+/-0.010	0.298	✓			
0.738	+/-0.010	0.736	✓			
0.25	+/-0.030	0.250	✓			
3.375	+/-0.010	3.377	✓			
4.875	+/-0.010	4.875	✓			
1.670	+/-0.010	1.670	✓			
Ø0.386	+0.006/-0.001	0.386	✓		PG.	
Ø0.266	+0.006/-0.001	0.266	✓		P.G.	
6.81	+/-0.030	6.813	✓			
6.35	+/-0.030	6.350	✓			
1.46	+/-0.03	1.46	✓			
0.050	+/-0.010	0.050	✓			
3.440	+/-0.010	3.438	✓			
4.968	+/-0.010	4.966	✓			
Ø0.875	+0.010/-0.001	0.875	✓			
0.332	+0.020/-0.010	0.330	✓			
Ø0.750	+/-0.010	0.752	✓			
6.49	+/-0.030	6.500	✓			
0.691	+/-0.010	0.690	✓			

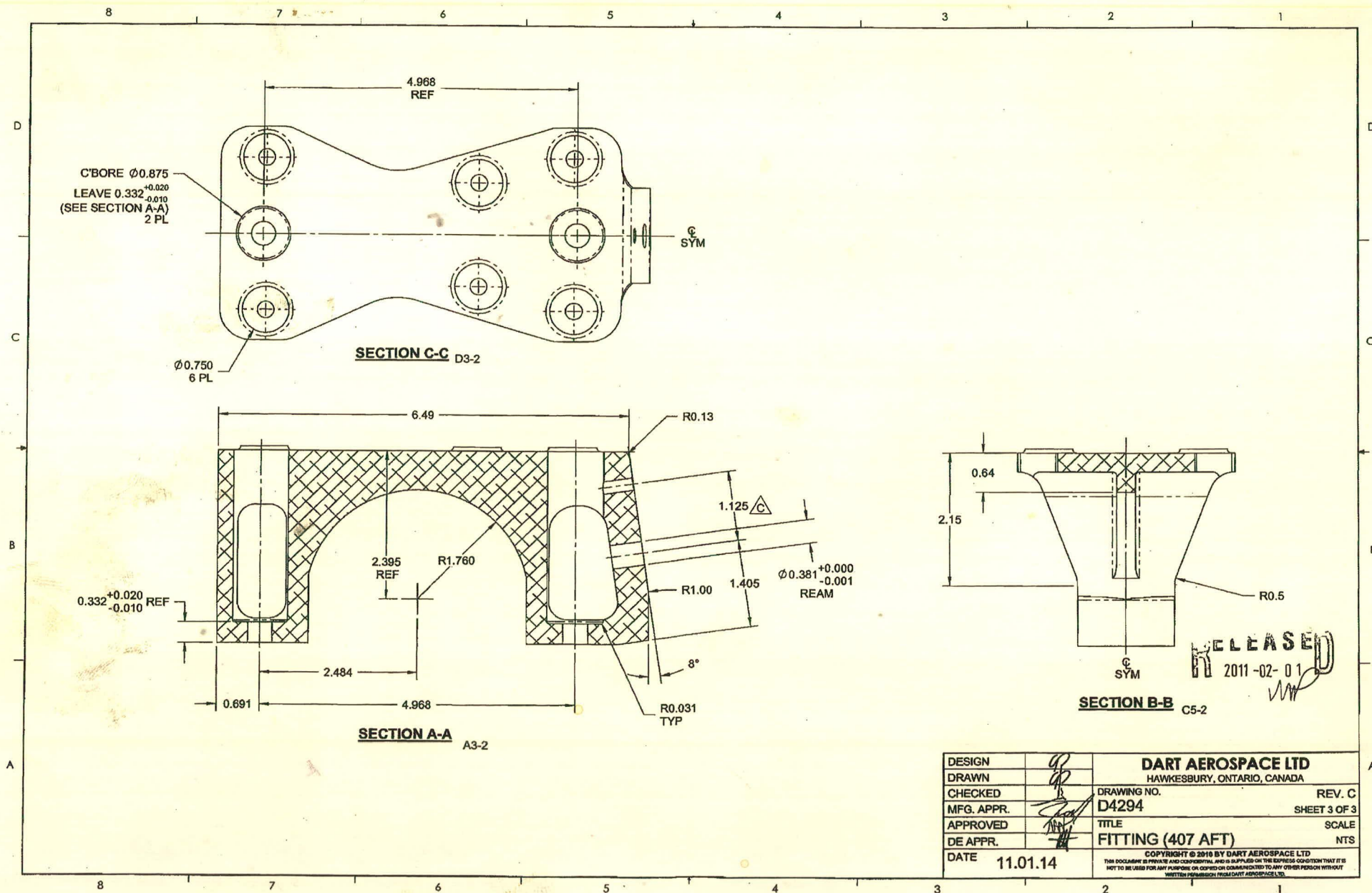
DART AEROSPACE LTD		Work Order:	
Description: Fitting		Part Number:	D4294-1
Inspection Dwg: D4294 Rev: C		Page 2 of 2	

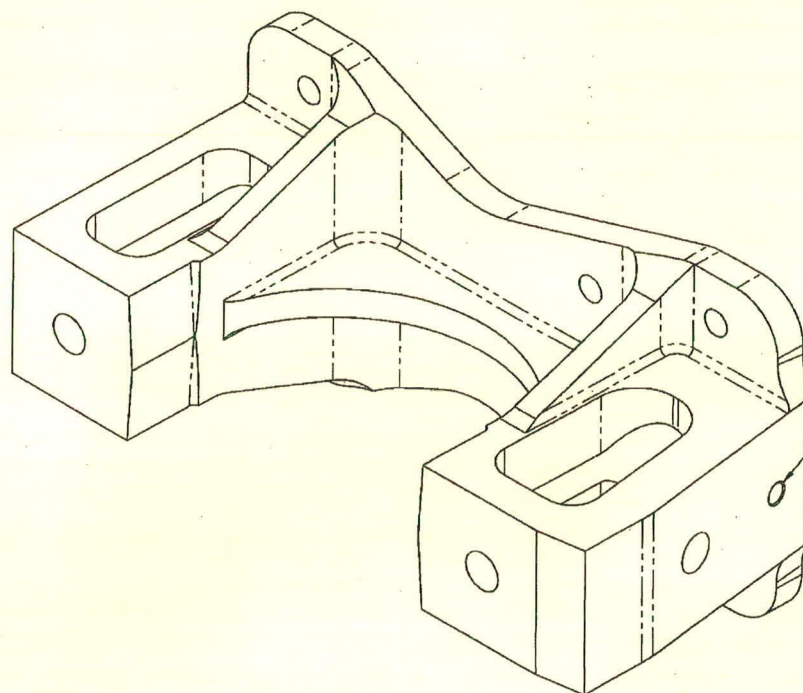
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.64	+/-0.030	0.634	✓			
Ø0.201	+0.005/-0.001	0.201	✓			
CSK Ø0.320 x 100°	+/-0.010	0.320 x 100°	✓			
0.764	+/-0.010	0.764	✓			
Ø0.381	+0.000/-0.001	0.3805	✓			
1.405	+/-0.010	1.405	✓			
1.125	+/-0.010	1.125	✓			

Measured by: DAS 57	Audited by: K.R. DAS 1	Preliminary Approval:
Date: 9-89 18/10/27	Date: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	14.09.08	New Issue	KJ	





MS21209F1-10 HELICAL COIL, 1X
REF

GRAIN
DIRECTION

D4294-1 FITTING

RELEASED
2011-C2-01

NOTES:

- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4294-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.55 lbs

C	ADD HELICAL COIL (D1-2, B4-3)	CP	11.01.14
B	0.780 WAS 0.76 (C6-2), 1.560 WAS 1.54 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.01.14		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4294	REV. C
TITLE FITTING (407 AFT)	SHEET 1 OF 3
	SCALE NTS
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